

Work Order ID 66341

Thursday, February 10, 2011 11:25:22 AM



ASAP

Page 1

Item ID: D2956

Accept



Setup Start



Revision ID:

Stop



Item Name: Window Frame

Start Date: 2/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *11-02-10*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2956

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2956
Deburr if necessary

☐ Dwg Rev:

C

☐ Prog Rev:

C

☐ 2-

5052

U40

B11-2-10

(2)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-2-10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sublot #4

(x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66341

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Item ID: D2956

Accept



Setup Start



Revision ID:

Stop



Item Name: Window Frame

Start Date: 2/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6 0 11/02/11

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:05. OVEN TEMPERATURE: 350° FINISH TIME: 10:25.

6 0 11-2-11

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 0 11/02/11

W/O:		WORK ORDER CHANGES						
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Item ID: D2956

Accept



Setup Start



Revision ID:

Stop



Item Name: Window Frame

Start Date: 2/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Identify as per dwg & Stock Location <u>2B</u>	0.00							
Packaging	Memo	0.00							
Packaging									
170 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/2/15

ca 11/02/15
ME
11-02-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Thursday, February 10, 2011 11:25:18 AM

Page 1

Work Order ID: 66341

Parent Item: D2956

Parent Item Name: Window Frame



Start Date: 2/10/2011

Required Date: 2/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A□00.01.14□New issue□EC
IPP Rev:B Now on Waterjet 07-06-25 JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	55.5234	3.2292	20.39495			



5052-H32 .040 Sheet



11-2-10

Location	Loc Qty	Loc Code
MAT	54.1	
114488	12	
116405	42.1	
MAT23	1.4234	
109058	0.0234	
113123	1.4	

116405 (6)

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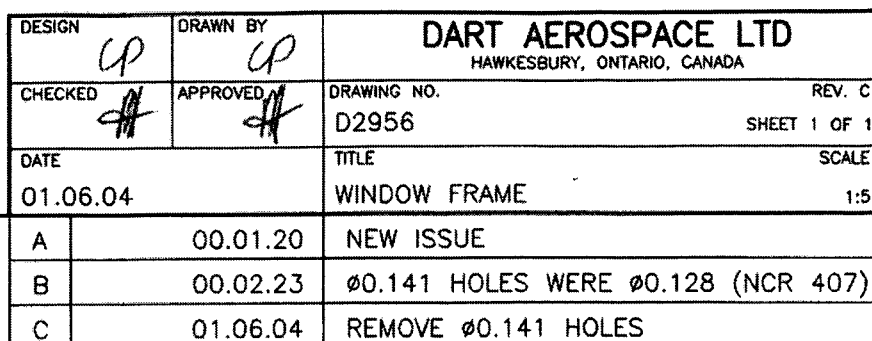
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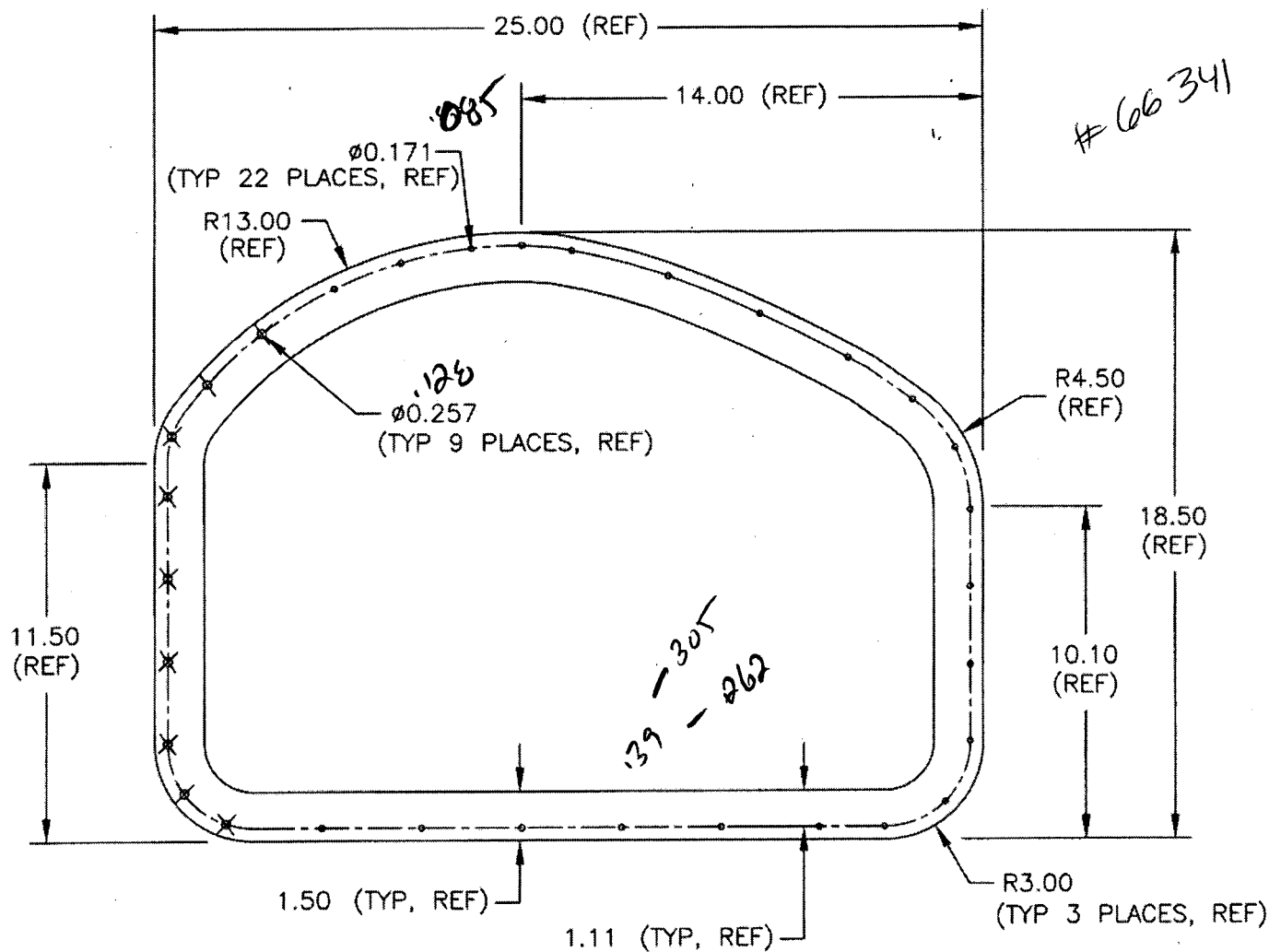
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RELEASED
01.06.05



MACHINE PER DRAWING FILE "D2956-C1.DWG".
CHECK HOLES PER TEMPLATE DT8437
BEND PER TEMPLATE DT8567
MATERIAL: 5052-H34 (QQ-A-250/8) SHEET 0.040 THICK
FINISH: POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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